



Chemlon® 109-18 G

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 18% Filler by Weight
Features	• High Impact Resistance
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.40 to 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	15200	psi	ISO 527
Tensile Strain (Yield)	3.0	%	ISO 527
Tensile Strain (Break)	6.0	%	ISO 527
Flexural Modulus	624000	psi	ISO 178/A
Flexural Stress	21500	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	> 4.3	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	428	°F	ISO 75-2/A
Melting Temperature	495	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms-cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	21	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 495	°F
Middle Temperature	495 to 520	°F
Front Temperature	505 to 535	°F
Nozzle Temperature	505 to 540	°F
Processing (Melt) Temp	505 to 540	°F

Notes

¹ Typical properties: these are not to be construed as specifications.